

Date: Friday, 30/05/2008 10:13:13 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: OUTER AFT SADDLE		
Job Number	: 39605			Part Number	: D5955		
Estimate Number	: 11080			Drawing Number	: D5955 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 30/05/2008	S.O. No.	:	Drawing Revision	: B		
Prsh Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 15/06/2008	Qty:	6
Previous Run	: 39198			Um:	Each		
Written By	:						
Checked & Approved By	: JUD 08.5.30						
Comment	: Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101013	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) D6101-013 (7075-T7351) Size 2.50" x 10.10" X 8.25" (Grain along 10.10") Batch: B 38696	
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3	
		Comment: HAAS CNC VERTICAL MACHINING #3	
		1-Machine as per folio D5955, Ensure Batch Number is entered	
		2-Machine Keyway	
		3-Deburr & Tumble	
3.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 30/05/2008 10:13:13 AM
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Drawing Name: OUTER AFT SADDLE

Job Number: 39605

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M107925



(6x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

1:15 PM

OVEN TEMPERATURE:

320 OF

FINISH TIME:

1:45 pm

m-1

08/06/09

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57921

Cust/10 (6)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/06/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.06.10 /

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order:	391605
Description: Outer Aft Saddle			Part Number:	D5955
Inspection Dwg: D5955 Rev: B			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.001	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.321	.321	.321	.321		
H	1.522	1.532		1.528	1.528	1.528	1.528		
I	3.048	3.058		3.051	3.051	3.050	3.050		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.505	.500	.500	.500		
M	0.490	0.510		.503	.503	.504	.505		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.000	8.002	8.002	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.760	.760	.760		
S	0.490	0.510		.501	.501	.500	.500		
T	1.625	1.645		1.633	1.634	1.631	1.635		
U	2.000	2.020		2.002	2.005	2.007	2.000		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									

Accept/Reject

Measured by:	8/	Audited by:	8/
Date:	08/06/05	Date:	08/06/06

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	DD

DART AEROSPACE LTD			Work Order:	391605
Description: Outer Aft Saddle			Part Number:	D5955
Inspection Dwg: D5955 Rev: B			Page 1 of 1	

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O	7.990	8.010		8.000	8.000				
P	2.240	2.260		2.250	2.250				
Q	0.307	0.312		.310	.310				
R	0.760	0.765		.760	.760				
S	0.490	0.510		.501	.497				
T	1.625	1.645		1.634	1.631				
U	2.000	2.020		2.005	2.005				
V	0.023	0.043		.033	.033				
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	84	Audited by:	84
Date:	08/06/06	Date:	08/06/06

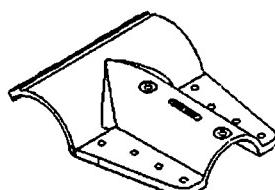
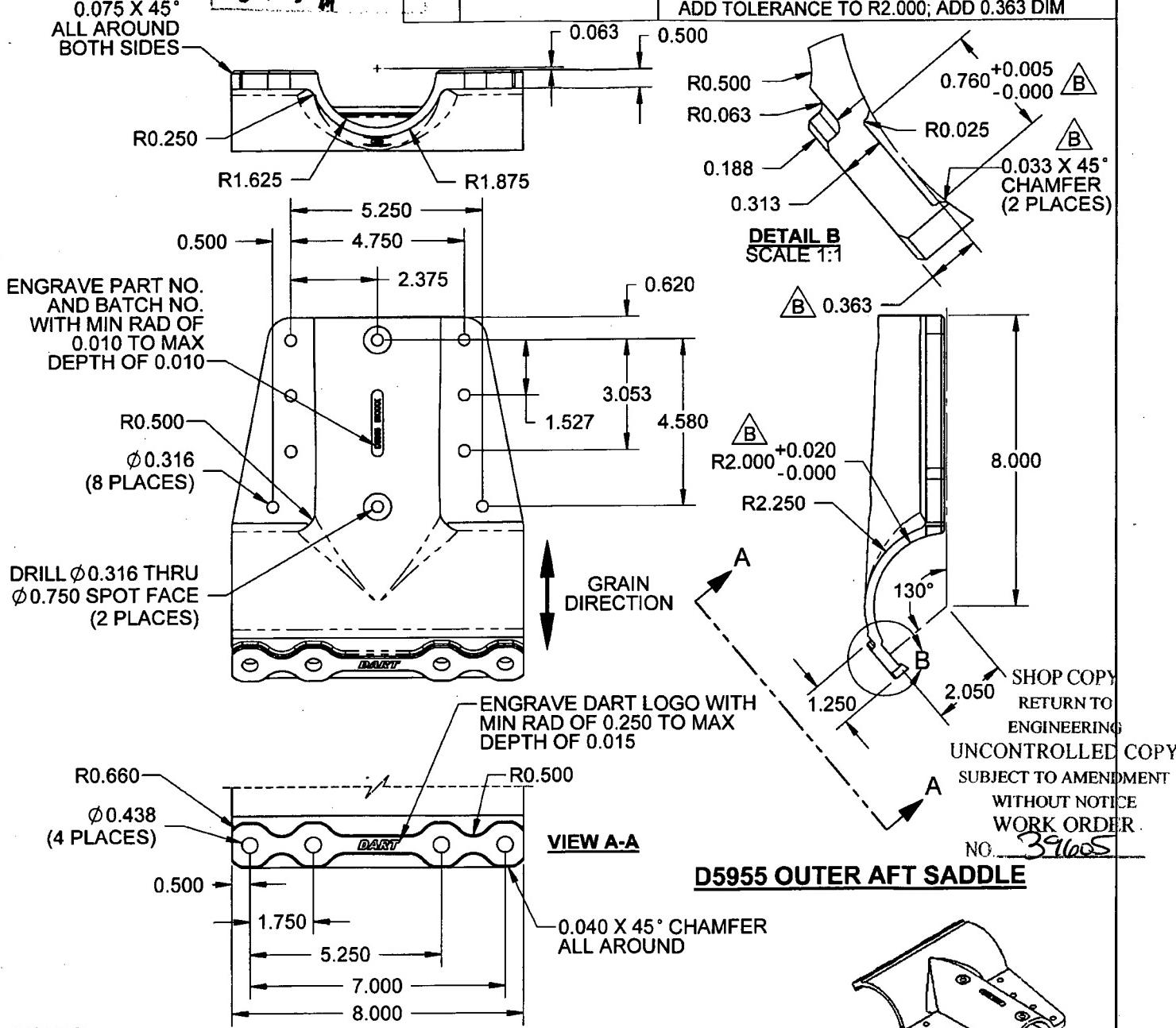
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F	08.04.21	Dimension E revised	KJ/DD	DD

DART

DESIGN BW	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D5955	REV. B SHEET 1 OF 1
DATE 06.11.07		TITLE OUTER AFT SADDLE	SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
REV B	DATE 06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø 0.316 WAS Ø 0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

REV B AS ISSUED

06.11.07



ISOMETRIC VIEW
SCALE 1:8

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3 B
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

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